

Work Order ID 147444

147444

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Wednesday, June 08, 2016 3:20:52 PM

Item ID: D3791-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 5/31/2016 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 10 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3791	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.07							
FLOW CNC Waterjet	1-Cut as per Dwg D3791								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									

8

ca 11/6/07/17

8

ca 11/6/07/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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120	QC8- Inspect parts - second check	0.00				(8)			DAS 38 9-89
120									
QC	Memo	0.02							JUL 20 2016
Quality Control									
130	NC BRAKE	0.01							
130					DAS 30 9-89	(8)			JUL 21 2016
Brake NC	Memo	0.01							
Brake NC	1-Deburr if necessary								
	2-Form on Brake as per Dwg D3791 using Jigs								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						(8)			DAS 38 9-89
QC	Memo	0.02							JUL 21 2016
Quality Control	Ensure joggle as per dwg D3429								

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180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M 134 852</i> Memo START TIME: <i>8:15</i> OVEN TEMPERATURE: <i>370</i> FINISH TIME: <i>8:45</i>	0.00 0.01				<i>8</i>	<i>16.08-19.</i>	<i>234</i>	<i>9-89</i>
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>(8)</i>		<i>DAS 38 9-89</i>	<i>AUG 19 2016</i>
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>FP-002</i> Memo LOCATION : FP002	0.00 0.01				<i>x8</i>	<i>d</i>	<i>22 1608/19</i>	

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Work Order ID 147444

Wednesday, June 08, 2016 3:20:52 PM

147444

Page 5

Item ID: D3791-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 5/31/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

DAS

21

9-00

AUG 19 2016

QC

Memo

0.10

Quality Control

DAS

21

9-00

AUG 19 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, June 08, 2016 3:20:55 PM

Page 1

Work Order ID: 147444

147444

Parent Item: D3791-1

D3791-1

Parent Item Name: Wearpad

Start Date: 5/31/2016

Required Date: 6/8/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	92.0172	0.2917	1.842316			

M304S16GA

304/316 Sheet .063

22/6/07/17

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	12.97	
m134677	12.97	
MAT019	0.9	
m134551	0.9	
TPI	78.14716	
m134604	78.14716	

134982

3

DQA: _____ Date: _____

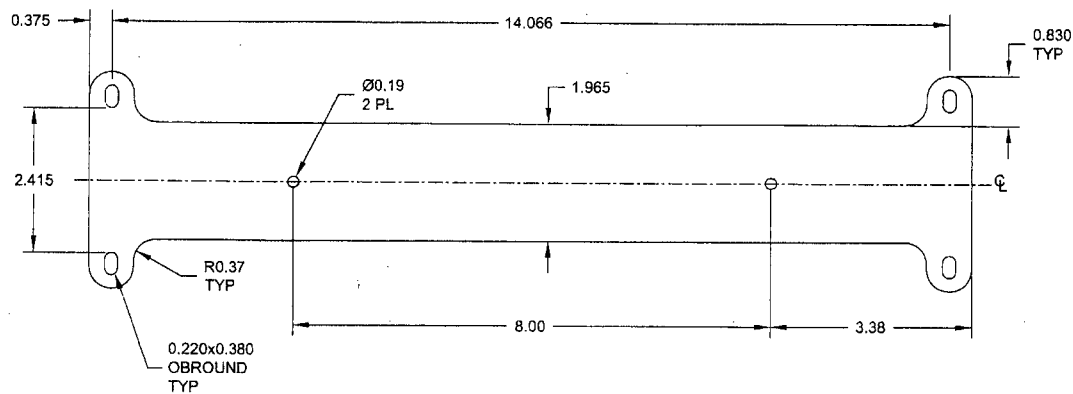


WORK ORDER NON-CONFORMANCE / UPDATE

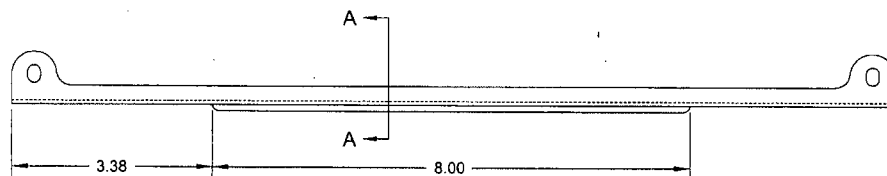
QA Closed: _____ Date: _____

Work Order update only ☐

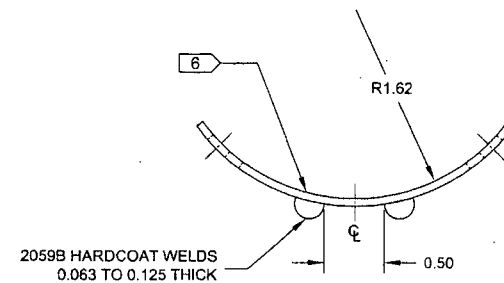
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OTHER :																									



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A		NEW ISSUE		PH	08.05.13
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3791		SHEET 1 OF 1	
APPROVED		TITLE		SCALE	
DE APPR.		WEARPLATE		NTS	
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